



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3556-1

Job Sheet 179710



Part No: D3556-1

Job Qty: 40 ea

Part Name: R44 Bearpaw Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07-03-23 JLM IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C 11.07.14 now in-house EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		7/18/18	0.00	0.00	Start Up Waterjet		de R/cw/21e
100	Waterjet	40 pcs		7/18/18	0.00	1.52	Waterjet1		de R/cw/21e
120	QC	40 pcs		7/18/18	0.00	0.00	QC8		38
130	Brake NC	40 pcs		7/18/18	0.01	0.67	Brake NC 1		9-89 DAS
140	QC	40 pcs		7/18/18	0.00	0.00	QC5		38
150	Packaging	40 pcs		7/18/18	0.00	0.00	Packaging3	5/542	AUG 14 2018
160	QC21-SA	40 Ea		7/18/18	0.00	0.00	QC21	9-89 21 9-89	AUG 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.5200 sf (.038 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	2	235	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.375inches ± 0.010	0.385 0.365		
2	Clamp	0.450inches ± 0.010	0.460 0.440		
3	Clamp	0.750inches ± 0.030	0.780 0.720		
4	Clamp	1.000inches ± 0.030	1.030 0.970		
5	Clamp	7.130inches ± 0.030	7.160 7.100		
6	Clamp	0.257inches + 0.005 - 0.001	0.262 0.256		
7	Clamp	0.375inches ± 0.010	0.385 0.365		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finish ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Wire/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	MRB (QSI042) Approval 							
Description Work Order Deviation 		Completed By 							
		Lead hand / Supervisor Approval Verification 							
		QC / QA Coordinator Approval 							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> B ☐ Ce ☐ Cra ☐ Crin. ☐ Cuffs ☐ Crush ☐ Heat Tre ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				B ☐ Ce ☐ Cra ☐ Crin. ☐ Cuffs ☐ Crush ☐ Heat Tre ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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 www.dartaero.com



Date: 06/25/18

8	Clamp	6.226inches $\pm$ 0.030	6.256 6.196
9	Clamp	0.063inches $\pm$ 0.010	0.073 0.053

Plex 6/21/18 7:21 AM Dart.lajeunesse.marie

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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